

# Work Order ID 52709

October 8, 2009 10:24:37 AM

Page 1

Item ID: D212-725-1-929

Accept

Setup Start

Revision ID: B

Stop

Item Name: HOUSING ASS'Y

Start Date: 10/08/09 Start Qty: 10.00

Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/10/08 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-725-1

Rev B

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 10546

E-mail or Ship electronic file and or dwg to vendor to  
manufacture the following:  
qty 10 D212-725-1-147

Manufacture as per Dwg and supplied files  
Possible supplier: Sieg's  
Material release note is required

CL 09/10/08 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00



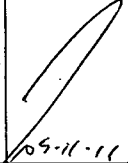
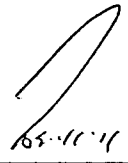
Packaging

Memo

0.00


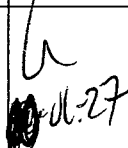
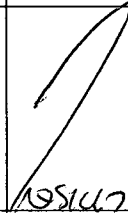
Packaging

CL 09/10/08 10  
CL 09/10/08 10

W/O: 52709		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/11/11	w/o dwg leader	change to <del>Rev. B</del> per dwg. D4238 Rev. A  perm change				 09/11/11	 09/11/11

Part No: D212-725-1-929 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/11/11	# WO	Found that Dim 2.25 is measure 2.31" AND Dim 1.503 is 1.533"	 09/11/11	inform supplier of Problem AND re order Replacements	 10/11/11	8 10/11/11	 09/11/11	8 09/11/11

NOTE: Date & initial all entries

# Work Order ID 52709



Page 2

October 8, 2009 10:24:37 AM

Item ID: D212-725-1-929

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Setup Start



Revision ID: B

Stop



Item Name: HOUSING ASS'Y

Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00	8/10/27			x10			
130  Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch <del>369</del>  Memo	0.00  0.00				<del>10-3-18</del>		<del>SL</del>	<del>10X</del>
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52709**

October 8, 2009 10:24:37 AM



Page 3

Item ID: D212-725-1-929

Accept



Setup Start



Revision ID: B

Stop



Item Name: HOUSING ASS'Y

Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							
160 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Costed at \$ 12-5-22  
see w/o  
#84740

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

October 8, 2009 10:24:37 AM

Work Order ID: 52709

Parent Item: D212-725-1-929RevB

Parent Item Name: HOUSING ASSY

Comments:

Start Date: 10/08/09

Required Date: 10/23/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-725-1-143		Manufactured	No				Each	0.0000	10.0000			
Base Plate												
D212-725-1-145		Manufactured	No				Each	0.0000	10.0000			
Tube												
D212-725-1-147P		Purchased	No				Each	0.0000	10.0000			
Cup												

52702

52705

69/11/10 (10) M113146?  
OR 52709

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

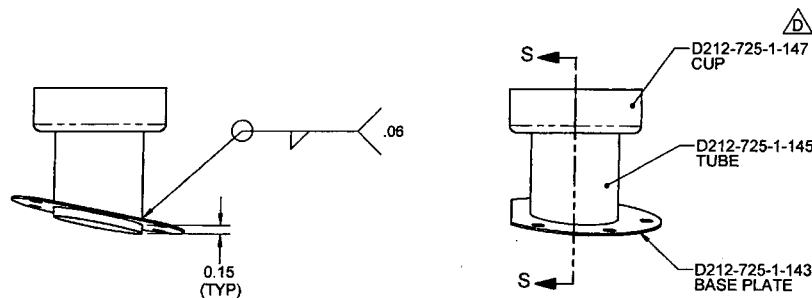
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

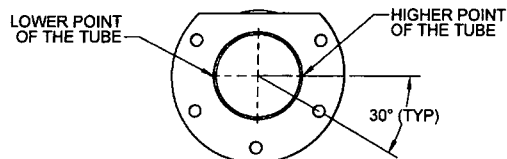


8 7 6 SHOP COPY 5 4 3 2 1

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52709  
C209110108



SECTION S-S



**D212-725-1-929 HOUSING ASSEMBLY**

RELEASED  
08-07-03/14

- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D212-725-1-929 USING FINE POINT PERMANENT INK MARKER
  - 6) WEIGHT: N/A
  - 7) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 49 OF 67
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	1:2
DATE	08.03.14	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

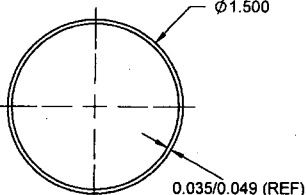
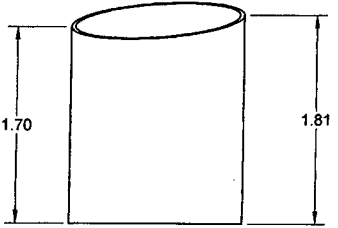
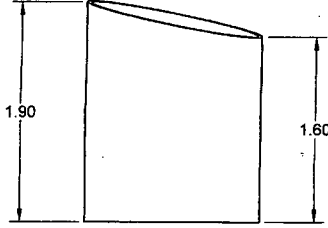
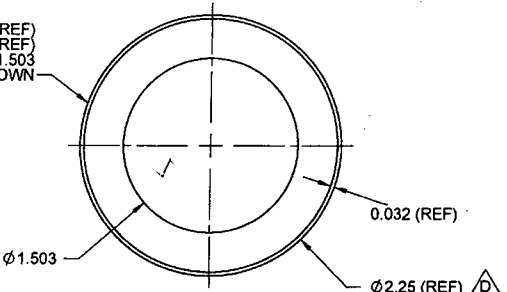
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

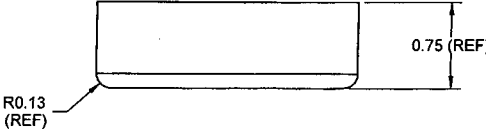
8 7 6 5 4 3 2 1



BELL P/N 204-060-767-001 (REF)  
OR 204-060-741-001 (REF)  
OPEN TO  $\phi 1.503$   
AS SHOWN



**D212-725-1-145 TUBE**



**D212-725-1-147 TUBE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER  
NO. 52709  
620910/08

RELEASED  
080703MD

- D212-725-1-145 NOTES:**
- 1) MATERIAL: AISI 304/316 SS  $\phi 1.500 \times 0.049/0.035$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.500W.049/.035)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 48 OF 67
APPROVED	#	TITLE	SCALE
DE APPR.	#	212S DETAIL PARTS	1:1
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

## Packing Slip

Packing Slip No.:

37256

Date:

11/06/2009

Page:

1

<b>Sold to:</b>		<b>Ship to:</b>	
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
<b>Order No.:</b>	10546	<b>Sold By:</b>	KAULBARS, KALE
<b>Shipped By:</b>	FED EX	<b>Ship Date:</b>	11/06/2009
<b>Tracking No.:</b>			

Item No.	Unit	Description	Quantity
D212-725-1-147P	EACH	SST CAP SPINNING	10
Comment:			

14312005

ASTM A 240/01A  
SPECIFICA: ASME SA 240/01  
SPECIFICATION: OOS 766 D/88  
ANFORDERUNGEN:

ASTM A 480/99B

**PRODOTTO:**  
**PRODUCT:**  
**PRODUIT:**  
**PRUEFEGEGENSTAND:**

## STAINLESS STEEL PLATES FROM COIL

**CERTIFICATO DI COLLAUDO**  
INSPECTION CERTIFICATE  
CERTIFICATE DE RECEPTION  
ABNAHMEPRÜFZEUGNIS B\*

EN 10204/3.1

0609989

PAG.

SM 1099 -

CLIENTE : DAVENPORT, FLORIDA  
CUSTOMER : 33897  
CLIENT : USA  
DESTINO :

ORDINE CLIENTE N°:  
CUSTOMER ORDER N°:  
COMMANDE DU CLIENT N°:  
BESTELLUNG N°:

ORDINE INTERNO N°: 8E060118  
INTERNAL ORDER N°:  
COMMANDE INT N°:  
WERKS N°:

AVV. DI SPEDIZ. N°:  
SHIPPING NOTICE N°: 00052307  
AVIS D'EXPEDITION N°:  
VERSANDANZEIGE N°:

COPPER AND BRASS  
19044 95A AVENUE  
SURREY BC V4N 4P2  
0 CANADA

W41928



N° ROTOLO COIL N° N° BOBINE BAND Nr.	N° COLATA HEAT N° N° COULÉE SCHMELZE Nr.	COMPOSIZIONE CHIMICA - CHEMICAL COMPOSITION - COMPOSITION CHIMIQUE - CHEMISCHE ZUSAMMENSETZUNG												
		% C	% Mn	% Si	% P	% S	% Cr	% Ni	% Mo	% N	% Ti	% Cu	%	%
1728341	0406744	.041	1.28	.33	.038	.002	18.08	8.01	.22	.055		.350		

**TIPO D'ACCIAIO:**  
**STEEL TYPE:**  
**TYPE D'ACIER:**  
**MARKENBEZEICHNUNG :**

**TIMBRO DEL PRODUTTORE:**  
PRODUCER TRADE MARK: ThyssenKrupp AcceI Speciali Temi S.p.A.  
MARQUE DU PRODUCTEUR:  
ZEICHEN DES LIEFERWERKS:

**TIMBRO DEL RESPONSABILE INCARICATO:**  
INSPECTOR STAMP;  
MARQUE DU RESPONSABLE CHARGE;  
STEMPEL DES WERKSACHVERSTÄNDIGEN:

This material does not contain Nickel of Cuban origin

80 CENTRO DI FINITURA P.F. TERNI

TRATT. TERMICO - RICOTTURA DI SOLUBILIZZAZIONE: 1050°C ARIA - ACQUA NEBULIZZATA - ACQUA  
HEAT TREATMENT - ANNEALING: AIR - WATER SPRAY - WATER COOLING  
TRAITEMENT - THERMIQUE - HYPERTEMPE: AIR - EAU ATOMISEE - EAU  
WÄRMEBEHANDLUNG - ABSCHRECKEN: °C/LUFT - SPROHWASSER - WASSER

PROCESSO DI ELABORAZIONE: E + AOD + CC  
STEELMAKING PROCESS  
PROCEDE D'ELABORATION  
ERSCHMELZUNGSART

IL MATERIALE È RESISTENTE ALLA CORROSIONE INTERGRANURALE SECONDO:  
THE MATERIAL IS RESISTANT TO INTERCRYSTALLINE CORROSION IN ACCORDANCE WITH:  
LE MATERIEL EST RESISTANT A LA CORROSION INTERGRANULAIRE SELON:  
DIE OBENGENANNTEN SCHMELZE IST BESTÄNDIG GEGEN INTERKRISTALLINE KORROSION GEMÄSS:

RISULTATI DELLE PROVE / TEST RESULTS / RESULTATS DES ESSAIS / ERGEBNIS DER PRÜFUNGEN (1 N/mm = 1 M Pa)																						
N° COLLO PACKAGE N° N° COLIS KISTEN Nr.	N° ROTOLO COIL N° N° BOBINE BAND Nr.	DIMENSIONI DIMENSIONS ABMESSUNGEN INCHES	N° PEZZI PIECES N° N° PIÉCES STÜCKZAHL	FINITURA FINISH FINITION AUSFÜHRG	PESO WEIGHT POIDS GEWICHT LBS Kg	PRELIEVO (1)	SENSO (2)	TRAZIONE / TENSILE / TRACTION / ZUGVERSUCH						DUREZZA HARDNESS DURETE HARTE		PIEGA BENO PLIAGE FALTVERSUCH α = 180°	GRANO GRAIN KORN (size)					
								Rp 0.2%	Rp 1%	Rm	A %			HR. B	H							
								N/mm²	N/mm²	N/mm²	Lo = 2"	Lo = 80	Lo = A5									
CARATTERISTICHE RICHIESTE - REQUIRED CHARACTERISTICS - CARACTERISTIQUES REQUISES - ANFORDERUNGEN								≥	30	≥		>	75	≥		≥		≤	92	≤		
C67780	1728341	035 X48.000X 120	50	2B	2877	T	T	38			93	62.3	63.8	81.0								
C67780						C	T	37			93	62.7	64.2	80.0								
C67781	1728341	035 X48.000X 120	36	2B	2072	T	T	38			93	62.3	63.8	81.0								
C67781						C	T	37			93	62.7	64.2	80.0								

001 2114 - 33863190

[illegible]

Certifichiamo che i prodotti sopra elencati sono conformi alle prescrizioni dell'ordine.  
We certified products listed above comply with order requirements.  
Nous certifions que les produits ci-dessus se conforment aux prescriptions de la commande.  
Wir bestätigen, dass die Lieferliste den Vereinbarungen der Bestellannahme entspricht.

COMPLIES WITH ED 2000/53

**ThyssenKrupp Acciai Speciali Terni S.p.A.**

FIRMA DEL RESPONSABILE INCARICATO  
INSPECTOR SIGNATURE  
SIGNATURE DU RESPONSABLE CHARGÉ  
UNTERSCHRIFT DES WERKSACHVERSTÄNDIGEN

Certificato emesso automaticamente

Sampling - Location - Ort  
T = Testa - Top - Tête - Kopf  
C = Coda - Bottom - Pied - Fuss

2) **Sense-Direction-Richtung**  
T = Transversale - Transverse - Traverse - Quer  
L = Longitudinale - Longitudinal - Long - Långs

MARCATURE:  
MARKING:  
MARQUAGE  
KENNEZEICHNUNG:

Wnr. - Type  
Heat n° - Coil N°  
Thickness - Finish

08-11-2006

G. TORTORETO

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 09/11/25
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Singer Manufacturing 6236-205 Street	
ADRESSE - ADDRESS		Langley B.C. V2Y-1N7	

513860

©BlueLine®, 2006







# Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

## Packing Slip

Packing Slip No.:

37256

Date:

11/06/2009

Page:

1

<b>Sold to:</b>  DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	<b>Ship to:</b>  DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 10546	<b>Sold By:</b> KAULBARS, KALE
<b>Shipped By:</b> FED EX	<b>Ship Date:</b> 11/06/2009
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
D212-725-1-147P <del>DIE</del>	EACH <del>EACH</del>	SST CAP SPINNING -- Re done. <del>DIE FOR D212-725-1-147</del>  Re shipped.	10 <del>4</del>
Comment:			



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO10546 -

Purchase Order Date 10/8/2009

PO Print Date 12/29/2009

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.  
6236 - 205 STREET  
LANGLEY, BC V2Y 1N7  
CA

REFERENCE ONLY

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	604 530 7455	Requisition Nbr	
Vendor Fax	604 530 7490	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D212-725-1-147P D	Cup	10/23/2009 Yes	10.00 Each	FedEx Economy	\$15.5000	\$155.00
		Special Inst:	MANUFACTURE AS PER DWG D212-725-1-147 REV. B B52709				
3		TOOLING SPINNING DIE	10/23/2009 Yes	1.00 Each	FedEx Economy	\$200.0000	\$200.00
		Special Inst:	NEW TOOLING (SPINNING DIE) FOR PART D212-725-1-147				
PO Total:							\$355.00

Change Nbr: 2

Change Date: 10/8/2009

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable